

Date: Wednesday, 1/11/2006 4:29:57 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PROP ARM ASSEMBLY
Job Number : 25476	
Estimate Number : 10730	
P.O. Number : N/A	Part Number : D2982041
This Issue : 1/11/2006 S.O. No. : N/A	Drawing Number : D2982 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 24627	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 2/15/2006 Qty: 15 Um: Each
Checked & Approved By : <u>SEE ABOVE USER</u>	
Comment : A 00.06.05 New Issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 15.0000 Each(s)

Clevis

Pick:

Qty	Part number	Description	Batch
1	D2012-107	Clevis	B25483

2.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 30.0000 Each(s)

Spacer

Pick:

Qty	Part number	Description	Batch
2	D2022-101	Spacer	B23396

3.0	D2429041	Spring Clip Ass'y
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 15.0000 Each(s)

Spring Clip Ass'y

Pick:

Qty	Part number	Description	Batch
1	D2429-041	Spring clip ass'y	B25484

P.T.O

4.0	D2588	Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 30.0000 Each(s)

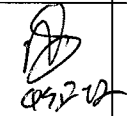
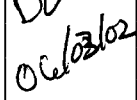

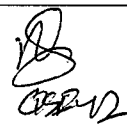
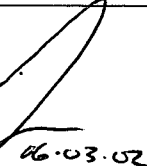
Bracket

Pick:

Qty	Part number	Description	Batch
2	D2588	Mounting channel	B24637

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/02	3.0	scraped 24/29-041 B25484 Qty=1 smiley face to deep into material	 06/03/02	Scrap & replace	 06/03/02	 06/03/02	 06/03/02	 06-03-02

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ARM ASSEMBLY

Job Number: 25476

Part Number: D2982041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2730

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Door Prop

Pick:

Qty Part number

Description

Batch

1

D2730

Prop arm

B24638

6.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Bolt

Pick:

Qty

Part number

Description

Batch

1

AN4-10A

Bolt

M18057

7.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Bolt

Pick:

Qty

Part number

Description

Batch

1

AN4-4A

Bolt

M17492

8.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty

Part number

Description

Batch

2

AN960JD416

Washer

M19085

9.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Rivet, Universal Head

Pick:

Qty

Part number

Description

Batch

2

MS20470AD45 Rivet

M17243 X 13, M18461 X 13

P10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.03.02	9	-5 rivet required. -C too long for Ass'y. Make change on Dwg ASAP, Change Not made since 2001. permanent change. <i>[Signature]</i>					<i>[Signature]</i>	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:29:57 PM  
User: Kim Johnston

## Process Sheet

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Drawing Name: PROP ARM ASSEMBLY

Job Number: 25476

Part Number: D2982041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Nut

Pick:

Qty

Part number

Description

Batch

2

MS21042L4

Nut

M17997

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2982

DL 06/03/02

(15)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 06/03/02

5

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 114

DL 06/03/03 (15)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/03/04

Job Completion



W 06/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

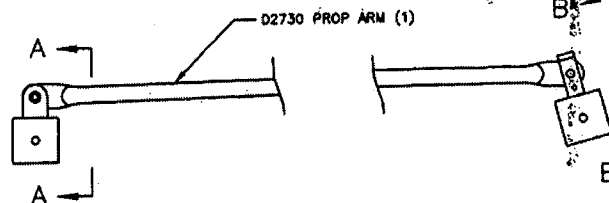


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2982	REV. A SHEET 1 OF 1
DATE 00.06.05		TITLE PROP ARM ASSEMBLY	SCALE NTS
A	00.06.05	NEW ISSUE	

RELEASED  
00.06.03 #



Qty -041	Part Number	Description
X	D2982-041	PROP ARM ASSEMBLY
1	D2012-107	CLEVIS
2	D2022-101	SPACER
1	D2429-041	SPRING CLIP ASSEMBLY
2	D2588	MOUNTING CHANNEL
1	D2730	PROP ARM
1	AN4-10A	BOLT
1	AN4-4A	BOLT
2	AN960JD416	WASHER
2	MS20470AD4-6	RIVET
2	MS21042L4	NUT (OR MS21042-4)

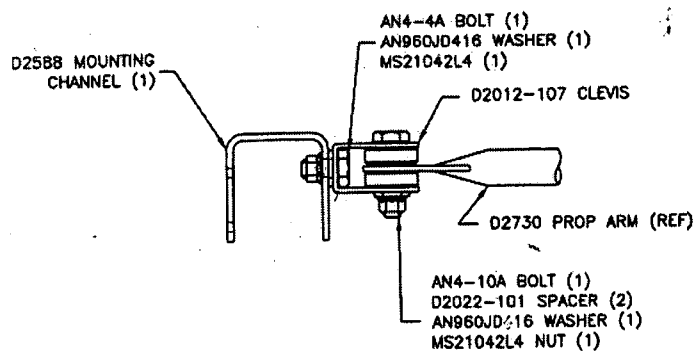


D2982-041 PROP ARM ASSEMBLY

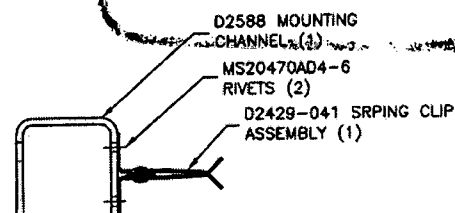
SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 25476



SECTION A-A



SECTION A-A

(PROP ARM REMOVED FOR CLARITY)

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